

18.58

Work Order ID 148583***148583***

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Tuesday, July 05, 2016 3:08:38 PM

Item ID: D2199-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Struts, 19"
 Start Date: 6/30/2016 Start Qty: 2.00 ***2*** Cust Item ID:
 Required Date: 7/8/2016 Req'd Qty: 2.00 ***2*** Customer:
 Reference:

Approvals: Process Plan: DAS 21 Date: JUL 12 2016 Tooling: Date: Run Start ***NR1***
 QC: 9-89 Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D2199	F

100 NC BRAKE 0.00
100
 Brake NC Memo 0.06
 Brake NC Punch per Dwg. D2199 and Spec Control Dwg D2638
 Deburr

2 Ø 17-1-3 **DAS 19 9-89**

120 QC5- Inspect part completeness to step on W/O 0.00
120
 QC Memo 0.01
 Quality Control

③ 17-01-03 **DAS 9 9-89**

130 White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel 0.00
130
 Powdercoat m 136113
 Powder Coating Memo 0.01
 START TIME: 11:10
 OVEN TEMPERATURE: 400°
 FINISH TIME: 11:10

2 Ø 17-01-04 **238**

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER :							
Misidentified ☐	Past Due ☐								

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140	QC3- Inspect Part Finish	0.00							
140						2			DAS 38 9-89
QC	Memo	0.00							JAN 09 2017
Quality Control									
150	Identify as per dwg & Stock Location: <u>3350</u>	0.00							
150						2			JAN 11 2017
Packaging	Memo	0.00							DAS 21 9-89
Packaging									
160	QC21- Final Inspection - Work Order Release	0.00							
160									DAS 21 9-89
QC	Memo	0.03							JAN 16 2017
Quality Control									

DAS
21
9-89
JAN 11 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order update only ☐

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Misidentified ☐	Past Due ☐																																																																	

Picklist Print

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Work Order ID: 148583

148583

Parent Item: D2199-1

D2199-1

Parent Item Name: Struts, 19"

Start Date: 6/30/2016

Required Date: 7/8/2016

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP B02.06.10Added finish NG/RF

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304TR0.750W.049		Purchased	No			100	f	183.9928	1.55	3.263158			

M304TR0 750W 049

304 RD Tube .750 x .049W

FF JAN 03 2017

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>	
GA002	136223	178.4200852	3.263158
M132270	0.00001		
M133131	0.0007242		
M133509	14.210211		
M133700	2.794323		
M133914	5.98516		
M134138	1.1364496		
M134212	8.5144235		
M134306	10.6695789		
M134528	3.7518392		
M134604	49.23105		
M134824	29.650527		
M134993	12.4757888		
M135093	40		
MAT	5.5727347		
M133400	5.5727347		

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Description Work Order Deviation		Disposition			
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				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

